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Hawkesbury, ON  
K6A 1K7  
Canada

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D3953-7

Job Sheet 191600



Part No: D3953-7

Job Qty: 40 pcs

Part Name: Spring Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/5/19

Job Tracking No:

Due Date: 3/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C IPP RevA: New issue DD verified by:EC IPP Rev:B as per dwg revC DD 10.03.02 verified by:EC

Ship Via:

## Bill of Materials

## Job Routing

| Op No | Operation                   | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|-----------------------------|--------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                             |        |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 100   | Hardinge - 1                | 40 pcs | 3/29/19    | 3/29/19  | 0.00      | 1.60    | Hardinge - 1          |           | 14/3/19  |
| 120   | QC 8                        | 40 pcs | 3/29/19    | 3/29/19  | 0.00      | 0.00    | QC 8 - 12             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 14             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 17             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 20             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 25             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 3              |           |          |
|       |                             |        |            |          |           |         | QC 8 - 32             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 33             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 35             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 39             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 4              |           |          |
|       |                             |        |            |          |           |         | QC 8 - 44             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 45             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 49             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 58             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 8              |           |          |
|       |                             |        |            |          |           |         | QC 8 - 9              |           |          |
|       |                             |        |            |          |           |         | QC 8 - 68             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 67             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 1 (A)          |           | 19/03/20 |
|       |                             |        |            |          |           |         | QC 8 - 47             |           |          |
|       |                             |        |            |          |           |         | QC 8 - 40             |           |          |
| 130   | Packaging 3-1 - Stock - B4B | 40 pcs | 3/29/19    | 3/29/19  | 0.00      | 0.00    | Packaging 3 - 1 - B4B |           |          |
|       |                             |        |            |          |           |         | Packaging 3 - 2 - B4B |           |          |
|       |                             |        |            |          |           |         | Packaging 3 - 3 - B4B |           |          |
|       |                             |        |            |          |           |         | Packaging 3 - 4 - B4B |           |          |
|       |                             |        |            |          |           |         | Packaging 3 - 5 - B4B |           |          |
|       |                             |        |            |          |           |         | Packaging 3 - 6 - B4B |           |          |
|       |                             |        |            |          |           |         | Packaging 3 - 7 - B4B |           |          |
|       |                             |        |            |          |           |         | Packaging 3 - 8 - B4B |           |          |

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DAS  
65  
9-89

|                                                                                                                                                                                                                           |                                     |                                |                  |                           |                         |
|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------|--------------------------------|------------------|---------------------------|-------------------------|
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 9 - B4B     |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 10 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 11 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 12 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 13 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 14 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 15 - B4B    | FP-001 XL 19-3-20       |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 16 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 17 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 18 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 19 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 20 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 21 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 22 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 23 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 24 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 25 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 26 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 27 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 28 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 29 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 30 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 31 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 32 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 33 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 34 - B4B    |                         |
|                                                                                                                                                                                                                           |                                     |                                |                  | Packaging 3 - 35 - B4B    |                         |
| 140 QC 21 - SA                                                                                                                                                                                                            | 40 pcs                              | 3/29/19                        | 0.00 0.00        | QC 21 - SA - 21           | MAK 21 2019             |
|                                                                                                                                                                                                                           |                                     |                                |                  | QC 21 - SA - 70           | DAS                     |
|                                                                                                                                                                                                                           |                                     |                                |                  | QC 21 - SA - 53           | 21<br>9-55              |
| Part Op 100 - Hardinge - TURN AS PER FOLIO FA854 & DWG<br>Descriptions: 120 - QC8- Inspect parts - second check<br>130 - Identify as per dwg & Stock Location: _____<br>140 - QC21- Final Inspection - Work Order Release |                                     |                                |                  |                           |                         |
| <b>Job BOM</b>                                                                                                                                                                                                            |                                     |                                |                  |                           |                         |
| <b>Part / Item</b>                                                                                                                                                                                                        | <b>Component Name</b>               | <b>Quantity</b>                | <b>Operation</b> | <b>Container</b>          |                         |
| MDELIRINR0.750                                                                                                                                                                                                            | Delrin Round Bar 0.75" Color: Black | 1.4400 ft (.036 ea)            | 100-Hardinge - 1 | <del>447</del><br>5149261 |                         |
| <b>Job Allocations</b>                                                                                                                                                                                                    |                                     |                                |                  |                           |                         |
| <b>Operation</b>                                                                                                                                                                                                          | <b>Component Part</b>               | <b>Required</b>                | <b>Inventory</b> | <b>Allocated</b>          |                         |
| 100-Hardinge - 1                                                                                                                                                                                                          | MDELIRINR0.750                      | 1                              | 93               | 0                         |                         |
| <b>Part Specifications</b>                                                                                                                                                                                                |                                     |                                |                  |                           |                         |
| <b>Spec No</b>                                                                                                                                                                                                            | <b>Description</b>                  | <b>Target/Tolerance</b>        | <b>Limits</b>    | <b>Type</b>               | <b>Special Comments</b> |
| 1                                                                                                                                                                                                                         | Gas Spring Spacer                   | 0.630Inches ± 0.030            | 0.660<br>0.600   | Diameter                  |                         |
| 2                                                                                                                                                                                                                         | Gas Spring Spacer                   | 0.257Inches + 0.006<br>- 0.001 | 0.263<br>0.256   | Diameter                  |                         |
| 3                                                                                                                                                                                                                         | Gas Spring Spacer                   | 0.370Inches + 0.000<br>- 0.030 | 0.370<br>0.340   |                           |                         |

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Entered: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. \_\_\_\_\_

Route update only ☐

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|------------------------|--|
| Job: _____<br><br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | <b>DISPOSITION</b><br><br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/> | <b>DEPARTMENT/PROCESS</b><br><br><div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/><br/>           Machining <input type="checkbox"/><br/>           Large Fab <input type="checkbox"/> </div> <div>           Cross tube <input type="checkbox"/><br/>           Small Fab <input type="checkbox"/><br/>           Finishing <input type="checkbox"/> </div> <div>           Eng. (Non-AW) <input type="checkbox"/><br/>           Prod. Eng. Coord. <input type="checkbox"/><br/>           Rec/Store/Packaging <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/><br/>           Water Jet <input type="checkbox"/><br/>           Supplier <input type="checkbox"/><br/>           Quality <input type="checkbox"/> </div> </div>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |  |                        |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | Sequence #:                                                                                                                       | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |  | MRB (QS1042)           |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                   | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  | Completed By           |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | Lead hand / Supervisor |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  | QC / QA Coordinator    |  |
|                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |
| <b>Root Cause</b><br><br><div style="display: flex; flex-direction: column;"> <div>Operator <input type="checkbox"/></div> <div>Manufacturing Process <input type="checkbox"/></div> <div>Equip/Tooling <input type="checkbox"/></div> <div>Handling/Preservation <input type="checkbox"/></div> <div>Material <input type="checkbox"/></div> <div>Product Improvement <input type="checkbox"/></div> <div>Process Improvement <input type="checkbox"/></div> <div>Human Factors <input type="checkbox"/></div> </div> |                                                                                                                                   | <b>FAULT CATEGORY</b><br><br><div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <input type="checkbox"/> Pressure/Forced<br/> <input type="checkbox"/> Bending<br/> <input type="checkbox"/> Crushing<br/> <input type="checkbox"/> Cracks<br/> <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist<br/> <input type="checkbox"/> Marks/Chatter<br/> <input type="checkbox"/> Mislabeled         </div> <div style="width: 50%;"> <input type="checkbox"/> Contamination<br/> <input type="checkbox"/> Misaligned/off center<br/> <input type="checkbox"/> BOM/Route<br/> <input type="checkbox"/> Broken/Damage/Defect<br/> <input type="checkbox"/> Incomplete/Unclear Instructions<br/> <input type="checkbox"/> Drill Holes<br/> <input type="checkbox"/> Fit/Function         </div> <div style="width: 50%;"> <input type="checkbox"/> Power Loss/Surge<br/> <input type="checkbox"/> Folio/Program<br/> <input type="checkbox"/> Grain Direction<br/> <input type="checkbox"/> Weld<br/> <input type="checkbox"/> Wrong Stock Pulled<br/> <input type="checkbox"/> Out of Sequence<br/> <input type="checkbox"/> Off-set/Set-up         </div> <div style="width: 50%;"> <input type="checkbox"/> Positioned Wrong<br/> <input type="checkbox"/> Outside Tolerance<br/> <input type="checkbox"/> Drawing<br/> <input type="checkbox"/> Finish<br/> <input type="checkbox"/> Part Lost/Missing<br/> <input type="checkbox"/> Misread         </div> </div> |  |                        |  |
| Other/Details:                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |                        |  |



**Container No: S163881**



**Part: D3953-7**

**Job No: 191600**

**Serial No/Batch: S163881**

**Revision:**

**Inspector:**

**Exp Date:**

**Instructions: Various STC's**

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**Date: 03/19/19**